

Work Order ID 59173

Thursday, May 27, 2010 12:36:29 PM



Page 1

Item ID: D350-748-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 5/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/5/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-748-241

Rev E

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-201 CHG001

8/10/08/70

HJ CL 10-8-19

110

0.00



CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

(IX) MB 10-06-08

120

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

CP 10.06.09 / 8/10/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Crosstubes

Crosstubes

Memo

0.00

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch: 109956

MB 10-06-09

ARM 10-06-09

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S 10/6/10

FL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 4 Date: 1008.18

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>59173</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.08.18	150	DAMAGE TO CAD PLATE DUE TO TRANSPORT ACCIDENT REF. NCR 10-308	<u>CP</u> 10.08.18 QS1042	Touch up CAD PLATE PER Q 10-350-748 CHAPTER 5	see next page	<u>S</u> 10/06/19	<u>CP</u> 10.08.18 QS1042	<u>/</u> 1008-18

NOTE: Date & initial all entries

CERTIFICATE OF
CONFORMANCE

CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1

DATE: Jul-05-2010

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 96461
INVOICE #: 50229

CONTRACT OR
PURCHASE ORDER #

12062

DESCRIPTION: SKID

QTY

1

P/N # D350-748-201



S/N # B59173

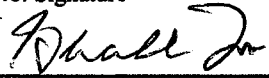
STRESS RELIEF HEAT CHART #10-634. MPI IAW ASTM-E-1444.
CADMIUM PLATE IAW AMS-QQ-P-416B TYPE 2 YELLOW CLASS 1.
BAKE HEAT CHART # 10-686.

*8/10/06/17 tube well damaged Durin transport.
See NCR next page.*

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector:

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form tracking No. HTV-2636 Page 1 of 1		
4. Approved organization name and address HELITRADES INC. 18 Terry Fox Drive, Vankleek Hill, Ontario, K0B 1R0, Canada					5. Work order/contract/invoice H-16610		
6. Item 1	7. Description CROSSTUBE	8. Part No. D350-748-201	9. Qty 5	10. Serial/Batch No. 55513 55516 55515 55514 59173	11. Status/work REPAIRED		
12. Remarks BRUSH CADMIUM PLATING REPAIR CARRIED OUT I.A.W. THE DART AEROSPACE ICA-D350-748 PAGE 9 OF 19 REV.1 DOCUMENTATION FOR ALL WORK PERFORMED IS AVAILABLE ON FILE UNDER HELITRADES W/O SPECIFIED IN BLOCK # 5.							
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release. <input type="checkbox"/> Other regulations specified in block 12. Certifies that, except where otherwise specified in block 12, the work identified in block 11 and described in block 12 was performed in accordance with the Canadian Aviation Regulations.				
13b. Signature		13c. Approved Organization Number		14b. Signature  GERALD TOM		14c. Approved Organization Number AMO 3/86	
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name GERALD TOM		14e. Date (dd/mm/yyyy) 17-Aug-10	
<p>"This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown."</p>							

(Previously form 24-0078)

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Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside crosstube as per QSI 005 4.2
2-Paint Outside of Tube as per Dart QSI 005 4.2

10-08-18 (X)

190

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

10-08-19 (X)

200

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install Ground wire Insert, then insert screw and washer
2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.
3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

10-08-19 (X)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/19

✗

220

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/8/20 SD

230

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/08/20

✗

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Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-748-201

Location: _____

PPP Rev: A

10/8/20

SP

250

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/28/27

MR

10-8-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 59173

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Comments: IPP Rev: A New Issue 06-07-05 JLM
IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

D350-748-241TRN

Manufactured No

110 Each

1.0000

1

1



Crosstube Turning Detail



B-47171 MB 10-06-08

Location

Loc Qty

Loc Code

LG

1

47170

1

ALS4-1032-225

Purchased

No

200

Each

7,062.000

1

1



Insert



RT 10-08-19

Location

Loc Qty

Loc Code

PK011

7062

110768

7062

AN960JD10

NAS1149D0363J

Purchased

No

200

Each

0.0000

1

1



Washer

m 115107 x 1



RT 10-08-19

D2856-400

Manufactured

No

200

f

269.1088

1.181

1.243158



Abraison Strip



RT 10-08-19

Location

Loc Qty

Loc Code

ST403

269.1088

50593

62.0568

56626

207.052

1- cut as per dwg D2856

x 1.2432

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 59173



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 5/27/2010

Required Date: 6/11/2010

Comments:

IPP Rev: A New Issue 06-07-05 JLM

IPP Rev: B Update qty of MS21042L5 06-09-12 KJ

IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD

IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3502-1

Manufactured No

200 Each

67.0000

2

2



Support



BT 10-08-19

Location

Loc Qty

Loc Code

ST066

67

47120

1

50287

38

52903

28

x2

MS21920-20

Purchased

No

200 Each

111.0000

2

2



BT 10-08-19

Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

111

112307

2

112624

32

112793

3

114687

50

114779

24

x2

MS27039-1-10

Purchased

No

200 Each

150.0000

1

1



BT 10-08-19

Screw

Location

Loc Qty

Loc Code

ST291

150

112794

50

112940

100

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 59173

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Comments: IPP Rev: A New Issue 06-07-05 JLM
IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-41A Purchased No 220 Each 134.0000 8 10/8/2010
Bolt

Location	Loc Qty	Loc Code
ST360	134	
110731	2	
111424	26	
112082	6	
113359	100	

AN4-6A Purchased No 220 Each 926.0000 16 10/8/2010
Bolt

Location	Loc Qty	Loc Code
ST356	926	
112933	96	
113149	600	
114523	30	
114615	200	

AN5-32A Purchased No 220 Each 186.0000 4 10/8/2010
Bolt

Location	Loc Qty	Loc Code
ST340	186	
113121	36	
114056	100	
114405	50	

AN960JD416 NAS1149D0463J Purchased No 220 Each 0.0000 32 10/8/2010
Washer

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

220

Each

0.0000

8

8



Washer



1114742 10/8/00

D3500-1 Manufactured No

220

Each

36.0000

4

4



Saddle



10/8/00

Location

Loc Qty

Loc Code

ST425

36

47119

1

52326

9

55605

26

D3501-1 Manufactured No

220

Each

479.0000

16

16



Bushing



10/8/00

Location

Loc Qty

Loc Code

ST066

479

45402

16

45918

159

48268

204

53779

100

10

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IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased No

220 Each

2,605.000

24

24



Nut



M114784 10/8/05

Location

Loc Qty

Loc Code

ST139

2

111827

2

ST300

2603

113422

80

114523

1515

114718

1000

9063

8

MS21042L5

Purchased No

220 Each

515.0000

4

4



Nut



M114713 10/8/05

Location

Loc Qty

Loc Code

ST300

515

113523

12

113537

3

114437

100

114449

400

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

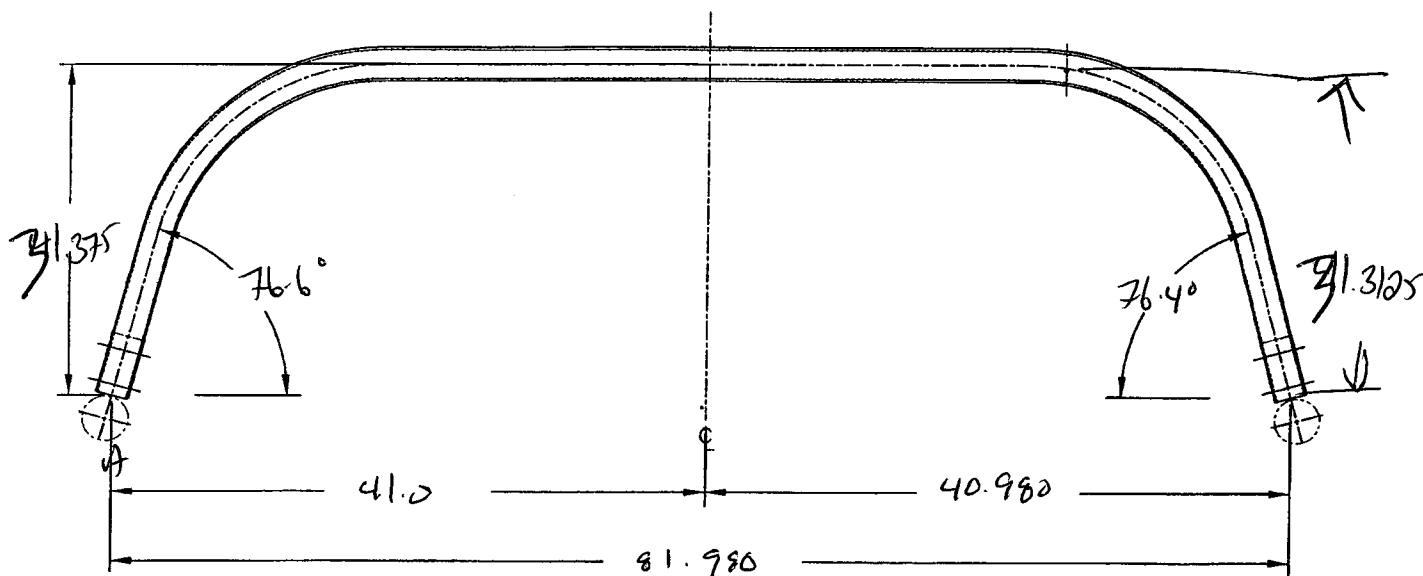
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DART AEROSPACE LTD		Work Order:	59173
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241	Rev: <i>DE 10/06/05</i>	Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
twist = 0.308"
OK <i>CP 10.06.05</i>

QC15 Inspection	<i>8</i>
Date	10/06/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>af</i>	<i>fu</i>

W/O:		WORK ORDER CHANGES					
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Item	Qty	Part Number	Description
	-241		
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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2009-10-29

E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 09-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. E D350-748-241 SHEET 1 OF 4 TITLE SCALE CROSSTUBE (AS 350/355 HI AFT) NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.09.30		

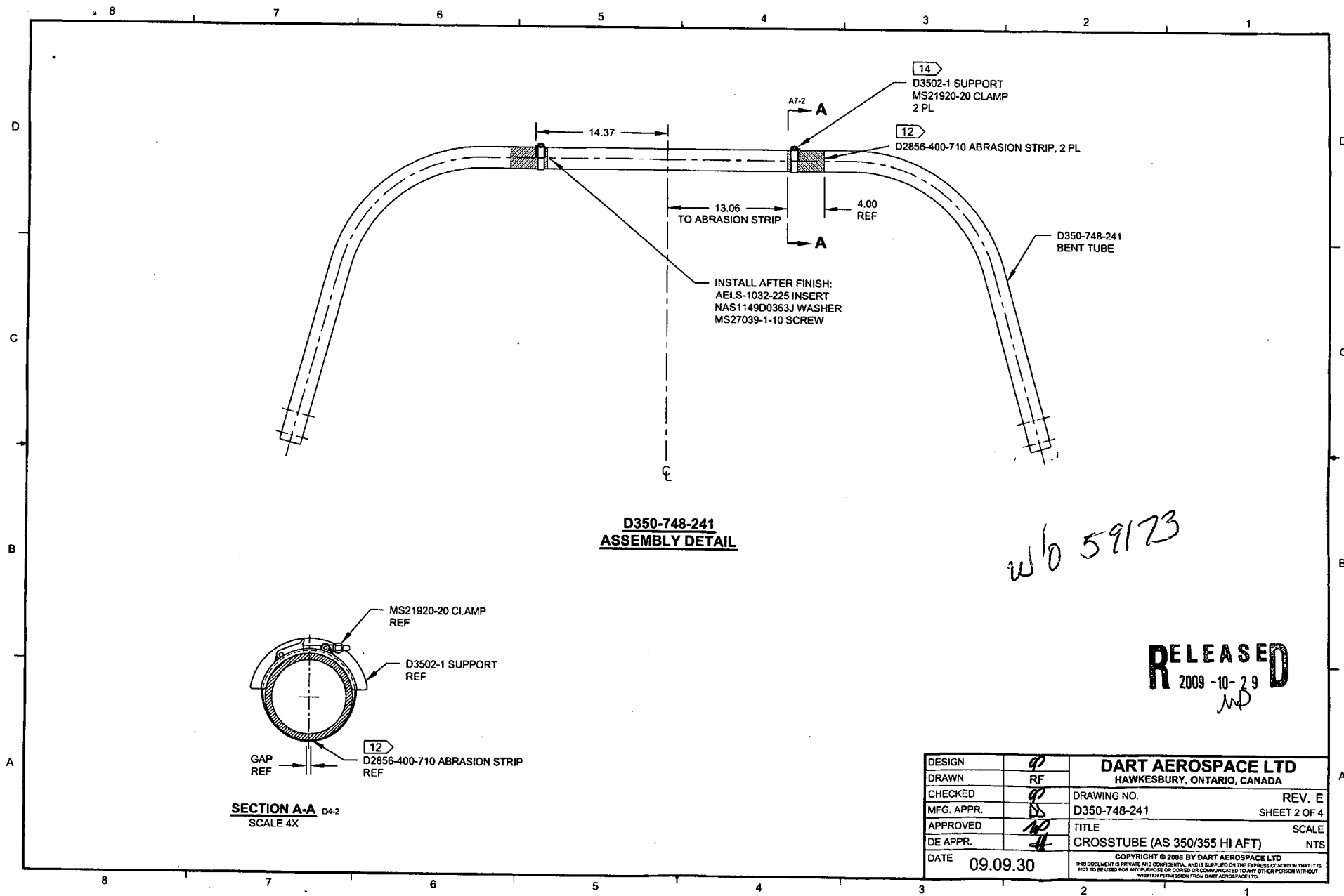
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/b 59173

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2009-10-29
MD

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. E
MFG. APPR.	DS	D350-748-241	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	4	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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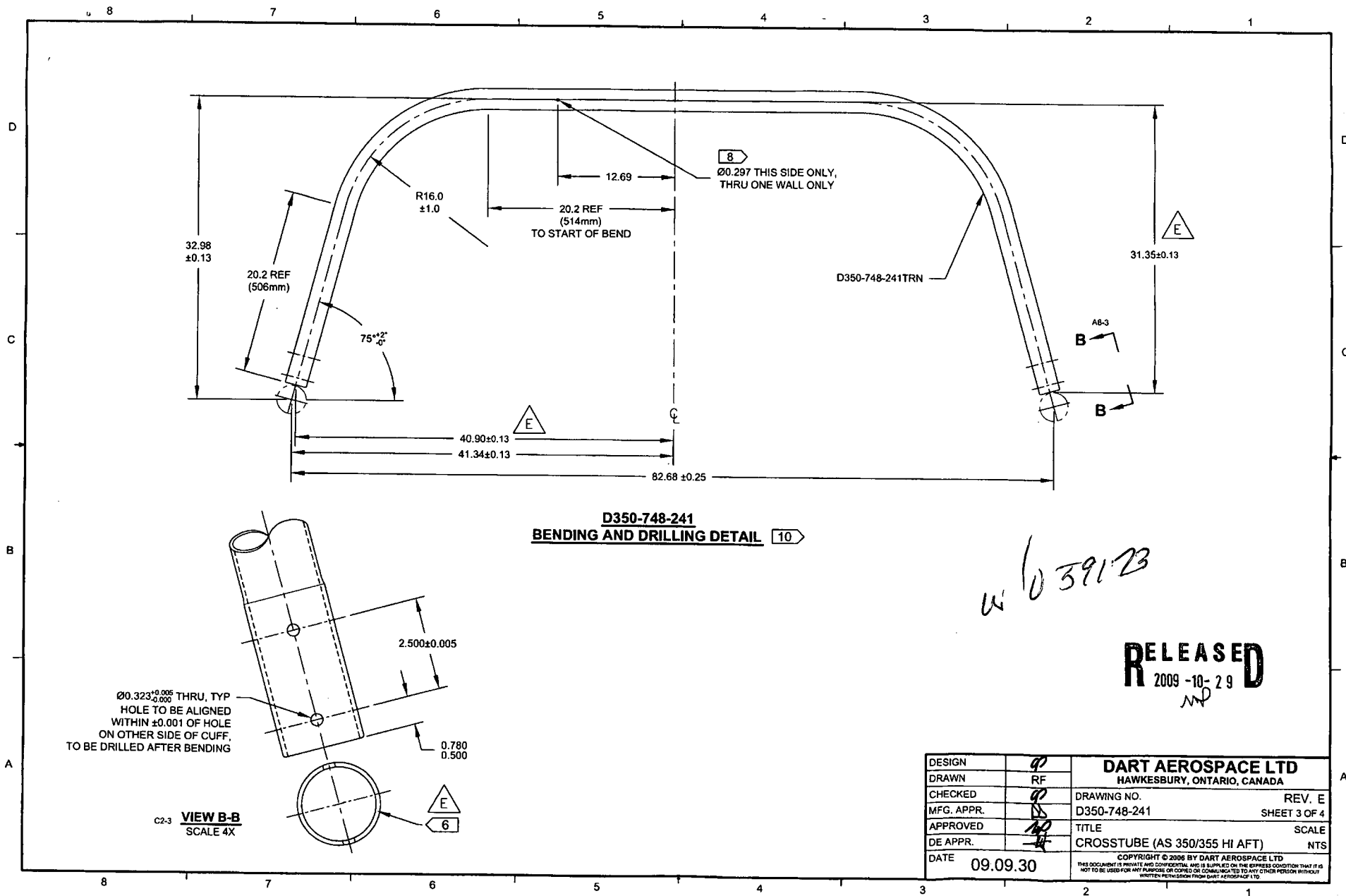
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>NS</i>	D350-748-241	SHEET 3 OF 4
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
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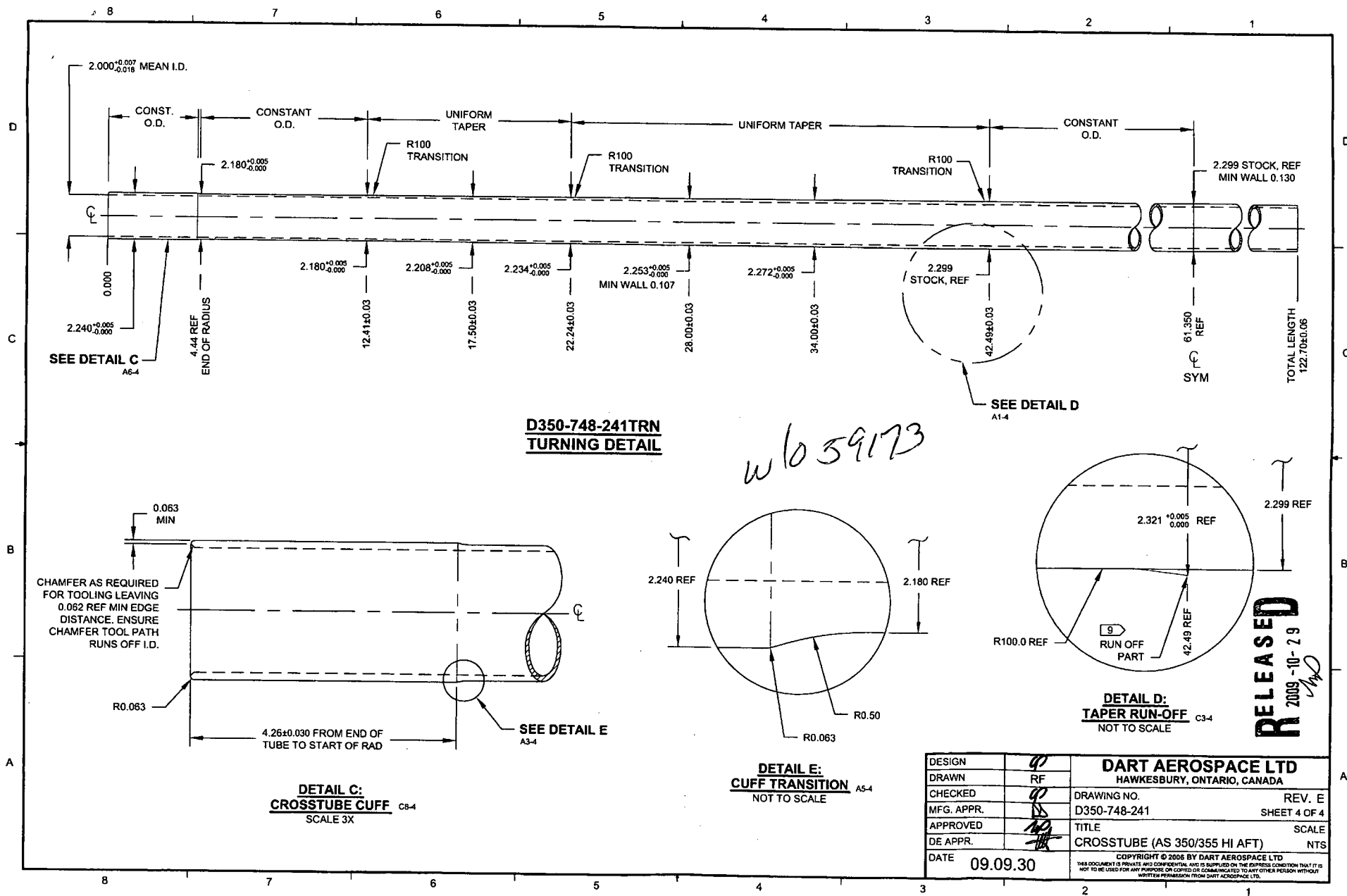
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W/O:		WORK ORDER/CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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